



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RBW6305G11831-3G-03
Job Sheet 198084



Part No: RBW6305G11831-3G-03

Job Qty: 1 pcs

Part Name: Threaded Shaft

6 pcs.

Part Weight: 0 lbs

Status: New

Job Created: 7/22/19

Priority: Medium

Due Date: 9/20/19

Job Tracking No:

Type: SOLD

Created By: Marie Lajeunesse

Description:

Note: DWG RBW6305G11831-3G Rev. 2 IPP Rev. A 18.09.24 New issue DP Verify DD
Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard Setup Hrs	Run Hrs	Workcenter/Supplier	Lead Time	Sign-off
120	SL-154 - 1	1		9/20/19	1.00	0.25	SL-154 - 1		
130	QC 2	1		9/20/19	0.00	0.00	QC 2 - 1		JB 19.09.04
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		
							QC 2 - 66		
							QC 2 - 64		

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 613 632-5200
Email: sales@dartaero.com
www.dartaero.com



Container No: S211490



Part: RBW6305G11831 - 3G - 03

Job No: 198084

Serial No/Batch: S211490

Revision: 2

Inspector:

Exp Date:

DAS
62
9-89

DAS
62
9-89

					QC 2 - 65	
					QC 2 - 5	
					QC 2 - 71	
					QC 2 - 73	
					QC 2 - 69	
140	Conventional Mill - 1 - B4B	1	9/20/19	0.00 0.17	Conventional Mill - 1 - B4B	
		pcs			Conventional Mill - 2 - B4B	
150	QC 2	1	9/20/19	0.00 0.00	QC 2 - 1	
		pcs			QC 2 - 12	
N/R					QC 2 - 14	
					QC 2 - 17	
					QC 2 - 19	
					QC 2 - 2	
					QC 2 - 20	
					QC 2 - 22	
					QC 2 - 23	
					QC 2 - 25	
					QC 2 - 32	
					QC 2 - 33	
					QC 2 - 35	
					QC 2 - 39	
					QC 2 - 4	
					QC 2 - 40	
					QC 2 - 44	
					QC 2 - 45	
					QC 2 - 48	
					QC 2 - 49	
					QC 2 - 50	
					QC 2 - 51	
					QC 2 - 52	
					QC 2 - 57	
					QC 2 - 62	
					QC 2 - 63	
					QC 2 - 8	
					QC 2 - 66	
					QC 2 - 64	
					QC 2 - 65	
					QC 2 - 5	
					QC 2 - 71	
					QC 2 - 73	
					QC 2 - 69	
160	QC 8	1	9/20/19	0.00 0.00	QC 8 - 12	
		pcs			QC 8 - 14	ML 2019-09-05
N/R					QC 8 - 17	
					QC 8 - 20	
					QC 8 - 25	
					QC 8 - 3	
					QC 8 - 32	
					QC 8 - 33	
					QC 8 - 35	
					QC 8 - 39	
					QC 8 - 4	
					QC 8 - 44	
					QC 8 - 45	
					QC 8 - 49	
					QC 8 - 58	
					QC 8 - 8	A.A 14-09-17

				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	
				QC 8 - 52	
				QC 8 - 23	
				QC 8 - 57	
170	Outsource - 13 - Zinc Plating	1 pcs	9/20/19	0.00 0.00	GROOZ 2019-09-09
180	Packaging 2-1 - Receive - B4B	1 pcs	9/20/19	0.00 0.00	Packaging 2 - 1 - B4B
					Packaging 2 - 2 - B4B
					Packaging 2 - 3 - B4B
					Packaging 2 - 5 - B4B
					Packaging 2 - 4 - B4B
					Packaging 2 - 6 - B4B
					Packaging 2 - 7 - B4B
					Packaging 2 - 8 - B4B
					Packaging 2 - 9 - B4B
					Packaging 2 - 10 - B4B
					Packaging 2 - 11 - B4B
					Packaging 2 - 12 - B4B
					Packaging 2 - 13 - B4B
					Packaging 2 - 14 - B4B
					Packaging 2 - 15 - B4B
					Packaging 2 - 16 - B4B
					Packaging 2 - 17 - B4B
					Packaging 2 - 18 - B4B
					Packaging 2 - 19 - B4B
					Packaging 2 - 20 - B4B
					Packaging 2 - 21 - B4B
					Packaging 2 - 22 - B4B
					Packaging 2 - 23 - B4B
					Packaging 2 - 24 - B4B
					Packaging 2 - 25 - B4B
					Packaging 2 - 26 - B4B
					Packaging 2 - 27 - B4B
					Packaging 2 - 28 - B4B
					Packaging 2 - 29 - B4B
					Packaging 2 - 30 - B4B
					Packaging 2 - 31 - B4B
					Packaging 2 - 32 - B4B
					Packaging 2 - 33 - B4B
					Packaging 2 - 34 - B4B
					Packaging 2 - 35 - B4B
					Packaging 2 - 36 - B4B
190	QC 6	1 pcs	9/20/19	0.00 0.00	QC 6 - 9
					QC 6 - 68
					QC 6 - 61
					QC 6 - 40
					QC 6 - 81
200	Packaging 3-1 - Stock - B4B	1 pcs	9/20/19	0.00 0.00	Packaging 3 - 1 - B4B
					Packaging 3 - 2 - B4B
					Packaging 3 - 3 - B4B
					Packaging 3 - 4 - B4B
					Packaging 3 - 5 - B4B
					Packaging 3 - 6 - B4B
					Packaging 3 - 7 - B4B
					Plex 7/22/19 11:36 AM Dart.lajeunesse.marie

				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
210 QC 21 - SA	1	9/20/19	0.00 0.00	QC 21 - SA - 21	
<i>closedwo on up</i>				QC 21 - SA - 70	SEP 16 2019
				QC 21 - SA - 53	
Part Op 120 - (MORI SL-154 LATHE) 1-Machine as per folio FC379 FOLIO REV: <u>AA</u> DWG REV: <u>2</u> 2- Descriptions: Deburr 130 - (QC2- Inspect parts off machine FAI/FAIB) 140 - (Manufacture as per dwg) 1-Machine as per DWG. 2-Deburr 150 - (QC2- Inspect parts off machine FAI/FAIB) 160 - (QC8- Inspect parts - second check) 170 - (Outside Processing - Zinc Plating) -Issue P/O to GROUPE ALTECH: P/O <u>44449</u> -Zinc plate, ASTM B633 TYPE 2 SC2 -Color; yellow -Material type; 4140 -Certificate of Conformity is required 180 - (Receive & Inspect for Damage & Mat'l Certs) 190 - (QC6- All purchased or subcontracted products) 200 - (Identify as per dwg & Stock Location: _____) 210 - (QC21- Final Inspection - Work Order Release)					
Job BOM					
Part / Item	Component Name	Quantity	Operation	Container	
MT-4140QT-R0.875	AISI 4140 Quenched & Tempered Steel Round Bar 0.875" Dia.	.4133 ft (.4133 ea)	120-SL-154 - 1	<u>5128382</u>	
Job Allocations					
Operation	Component Part	Required	Inventory	Allocated	
120-SL-154 - 1	MT-4140QT-R0.875	0	32	0	
Part Specifications					
Specifications could not be found.					

GA141E

DawM

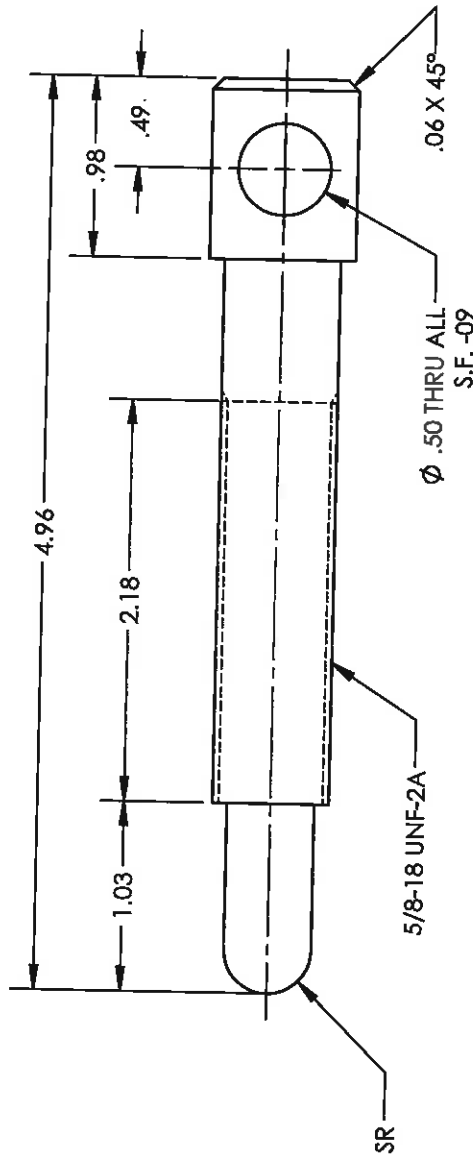
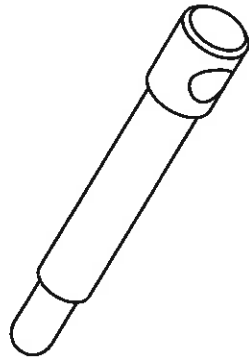
DAS

70

9-89

This drawing, specifications, and concepts contained here in are the sole property of Dart Aerospace, and may not be reproduced or used in any fashion without the prior written permission of Dart Aerospace Eugene, OR.

REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
1		CHTD -03 FINISH SPEC PER R.W. & CHTD HOLE FROM Ø.390 PER S.E.	5/4/2011	RJC	
2		-03 CHTD DIM WAS Ø.448 S.F. -09 IS Ø.50 S.F.-09. SEPARATED SR CALLOUT FROM DIM.	5/17/2015	DPD	JAG



TITLE		PULLER, MGB INPUT GIMBAL REMOVAL	
DWG NO.	RBW6305G11831-3G-03	REV	2
MAT'L	4140 Q&T/4142 Q&T	DRAWN BY:	PERRITT
UNLESS OTHERWISE SPECIFIED	APPROVED	DATE	5/17/2015
DIMENSIONS ARE IN INCHES	REVIEW	DATE	5/17/2015
XX ± .006	FINISH	DATE	5/17/2015
XX ± .01	ANGLES ± 5°	DATE	5/17/2015
XX ± .01	ANGLES ± 5°	DATE	5/17/2015
1. BREAK ALL SHARP EDGES .016 x 45°	SPEC	DATE	5/17/2015
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	USED ON MODEL	DATE	5/17/2015
SCALE	1:1	DATE	5/17/2015
SHEET 3 OF 6			

UNCONTROLLED
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 198084MCS
19-07-22

Ø.03

THREADED SHAFT



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

POHB044449



Supplier: GRO002-VC
Group Altech
2455 Halpern
St Laurent
QC
H4S 1N9 Canada
Phone: 514-335-3666
Fax: 514-335-3868

Attention: Grenon, Sylvie

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: POHB044449

PO Date: 9/9/19

Due Date: 9/17/19

**Purchase Order
Revision:**

Revision Date:

Ship-To Contact: Guerin, Kimberley
Phone: 613-632-5200 Ext: 298
kguerin@dartaero.com

Via: Ground

Pymt Terms: Net 60

Freight Terms:

Special Comments:

E-MAILED
2019-09-10

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	198084	RBW6305G11831-3G-03	Threaded Shaft (Outside Processing - Zinc Plating) - Issue P/O to GROUPE ALTECH -Zinc plate, ASTM B633 TYPE 2 SC2 -Color; yellow -Material type; 4140 -Certificate of Conformity is required	Firmed	-	9/17/19	6 pcs	0 pcs	6 pcs	\$0.87/pcs	\$5.22
						SEP 13 2019					
							5211490				
2	198064	RBW6305G11331-3G-01	Wrench Weldment Outsource13 (Outside Processing - Zinc Plating) -Issue P/O to GROUPE ALTECH: P/O -Zinc plate, ASTM B633 TYPE 2 SC2 -Color yellow -Certificate of Conformity is required	Firmed	-	9/17/19	6 pcs	0 pcs	6 pcs	\$12.03/pcs	\$72.18
						SEP 13 2019					
							5211735				



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

POHB044449



Items											
Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
3	198073	RBW6305G11631-3G-09	Cup Outsource13 (Outside Processing - Zinc Plating) -Issue P/O to GROUPE ALTECH: P/O -Zinc plate, ASTM B633 TYPE 2 SC2 -Color yellow -Certificate of Conformity is required	Firmed - XG	-	9/17/19	6 pcs	0 pcs	6 pcs	\$1.52/pcs	\$9.12
							SEP 13 2019			DP	
							SZ11088				
4	198086	RBW6305G11831-3G-07	Thumb Screw (Outside Processing - Zinc Plating)-Issue P/O to GROUPE ALTECH: P/O -Zinc plate, ASTM B633 TYPE 2 SC2 -Color; yellow -Material type; 1018 -Certificate of Conformity is required	Firmed - XIZ	-	9/17/19	12 pcs	0 pcs	12 pcs	\$1.17/pcs	\$14.04
							SEP 13 2019			DP	
							SZ11773				
Grand Total:											\$100.56

Order Notes

Procurement Quality Clauses
A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 9/10/19 10:06 AM Dart.Guerin.Kimberley



Certificat de Conformité / Certificate of Compliance

(022254-1)

2455, Rue Halpern | Saint-Laurent | Québec | H4S 1N9
 Tel: 514-335-3666 Fax: 514-335-3868
 www.groupealtech.com

Bon de Livraison / Packing Slip

022254 - 1

Livré à / Ship to

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 Tel.: 613-632-5200 Fax.:

Client / Customer:

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 BUYER:

Date expédition Ship date		Créé Par Generated By	Transport / No de Compte Courier / Acc. No.	Bon de commande Client Customer Purchase Order No.					
12-Sep-2019		Jigar Patel		POHB044449					
#Ligne Line#	No. de Série / # Pièce Part Number / Line Item Details Job # / Ref #	Description pièce(s)	CATG. U/M	Comm. /Ordered	Exp/ Shipped	Qté NC/ NC Qty	Qté Scrap/ Scrap	À venir/ Back Order	
1	RBW6305G11831-3G-03 Rev.	RBW6305G11831-3G-03 ZINC-YELLOW [ZINC YELLOW] OLD YELLOW CHROMATE, 96 hours AS PER ASTM B633 TYPE - 2, SC - 2 0.0003 " THICKNESS	ZINC CH	6	6	0	0	0	
2	RBW6305G11331-3G-01 Rev.	RBW6305G11331-3G-01 ZINC-YELLOW [ZINC YELLOW] OLD YELLOW CHROMATE, 96 hours AS PER ASTM B633 TYPE - 2, SC - 2 0.0003 " THICKNESS	ZINC CH	6	6	0	0	0	
3	RBW6305G11631-3G-09 Rev.	RBW6305G11631-3G-09 ZINC-YELLOW [ZINC YELLOW] OLD YELLOW CHROMATE, 96 hours AS PER ASTM B633 TYPE - 2, SC - 2 0.0003 " THICKNESS	ZINC CH	6	6	0	0	0	
4	RBW6305G11831-3G-07 Rev.	RBW6305G11831-3G-07 ZINC-YELLOW [ZINC YELLOW] OLD YELLOW CHROMATE, 96 hours AS PER ASTM B633 TYPE - 2, SC - 2 0.0003 " THICKNESS	ZINC CH	12	12	0	0	0	

RECEIVED
 SEP 13 2019
 DART AEROSPACE LTD.

Notes Additionnelles / Additional Notes

Épaisseur réelle
Actual Thickness

Inspecteur Qualité
Quality Inspector

Réçu par
Received By

Jc Jay

Nous certifions que les pièces énumérées ci-dessus ont été traitées en conformité avec votre commande et vos spécifications et rencontrent les exigences.
 Notre responsabilité financière et légale ne sera pas supérieure au montant de la facture issue.

We hereby certify that the parts listed above have been process in accordance with your purchase order and specifications and are in conformance with your requirements.
 Our financial and legal responsibility will not be higher than the amount of invoice.